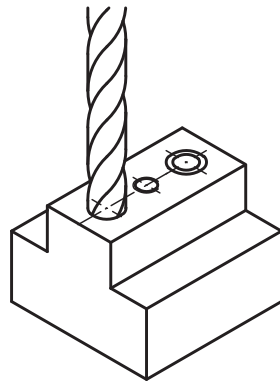
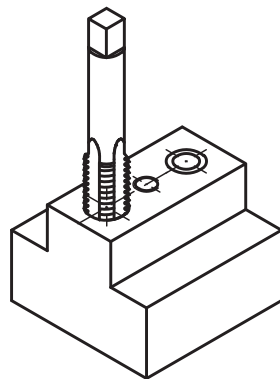


Operating Instructions for Threaded Inserts

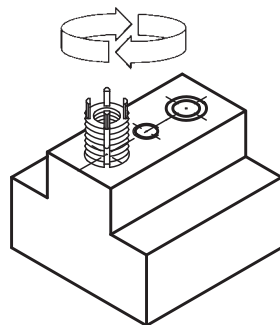
Installation Instructions



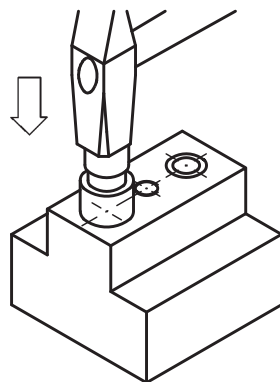
- 1.***
Rebore the old thread and countersink it (82° – 100°)



- 2.***
Tap planned thread with a standard screw tap



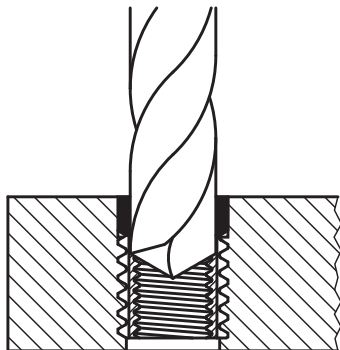
- 3.**
Screw in the insert to just below the surface (0.3 – 0.7 mm)



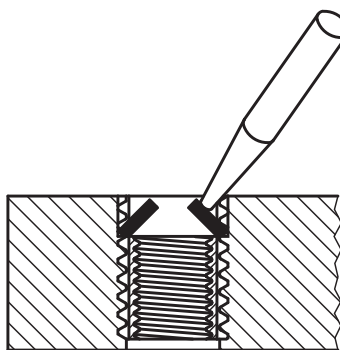
- 4.**
Drive in the locking pins by striking the assembly tool lightly with a hammer

* For steps 1 and 2 see table under installation of threaded inserts

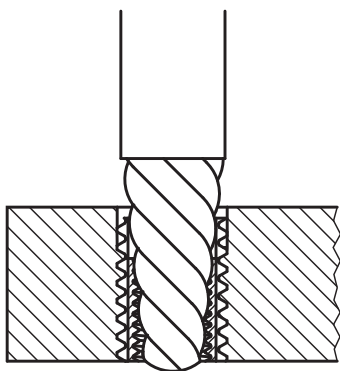
Removal Instructions



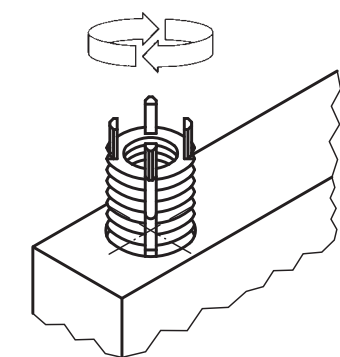
- 1.***
Rebore the material between the locking pins and the internal thread to the specified depth



- 2.**
Bend the locking pins inwards and break them off



- 3.**
Remove the old insert with a screw extractor



- 4.**
Install a new threaded insert in the original threaded hole

* For step 1 see table under removal of threaded inserts